

Stainless Stick (SMAW) Stainless Solid Wire (GMAW) Stainless Cut Legnth (GTAW) Stainless Flux Cored (FCAW-G) Stainless Metal Cored (MCAW) Stainless Sub Arc (SAW) Stainless Sub Arc (SAW)

Cost per kilogram referencing commercial selling prices for each electrode type.

Some processes, like SMAW, by nature have a tendency to produce more spatter than other processes such as GTAW welding or SAW.

Equipment Complexity Skill Level Required Stainless Stick (SMAW) Stainless Stick (SMAW) Stainless Solid Wire (GMAW) Stainless Solid Wire (GMAW) Stainless Cut Legnth (GTAW) Stainless Cut Legnth (GTAW) Stainless Flux Cored (FCAW-G) Stainless Flux Cored (FCAW-G) Stainless Metal Cored (MCAW) Stainless Metal Cored (MCAW) Stainless Sub Arc (SAW) Stainless Sub Arc (SAW) Less More More

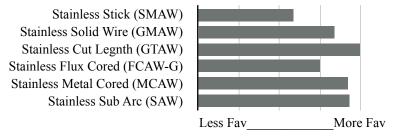
GTAW, MCAW and GMAW equipment that have pulse capability have more input variables and can be more complex than a process using a constant current (CC) or constant voltage (CV) power source.

Bead Appearance

Productivity

The key to success in all welding joints is proper set up. However, some

welding processes are difficult to master than others. For this reason,

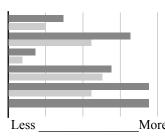


Due to its high surface sheen, most stainless steel welds are required to blend well into the base material. GTAW accomplishes this, but is very slow.

■ Flat/Horizontal

GTAW requires the most skill.

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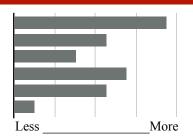


Vertical/Overhead

The productivity scale is comparing the kilos per hour of weld metal deposited.

Probability/Outdoor Use

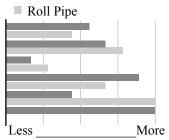
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Processes relying on external shielding gas such as GTAW and GMAW are less suited for portable use than SMAW. While submerged arc welding could be implemented outdoors, the setup does not make it very portable.

Pipe Welding Productivity

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6G position requires all-position capable electrodes and will by nature have lower deposition rates. Roll pipe applications position the weld so that it is always in the flat position to maximise productivity and deposition rates.



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